



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:47:56 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACESS STEP LH

Job Number: 33919

Part Number: D206628021BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3394043

LUG ASSY



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

16

Qty Part Number

Description

Batch

4 D3394-043

LUG ASSY

B34113

607/11

7.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

16

Qty Part Number

Description

Batch

4 AN4-12A

Bolt

M105143 (8L)

M104547 (8L)

8.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

16

Qty Part Number

Description

Batch

4 AN4-13A

Bolt

M104746 -

9.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

16

Qty Part Number

Description

Batch

4 AN4-15A

Bolt

M104072 -

10.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick:

40

Qty Part Number

Description

Batch

12 AN960JD416

Washer

M104746 -

11.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick:

40

Qty Part Number

Description

Batch

12 MS21042L4

Nut (or MS21042-4)

M104248 -

P10  
EP 507/08/06 (4)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 07/09/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/11	11.0	1 kit missing 2 nuts MS210 4214 P.C. Hamman error	<i>[Signature]</i> Resman	open kit and add the missing parts.	<i>[Signature]</i> 14/09/11	Er 07/09/11	<i>[Signature]</i> Resman	Er 14/09/11

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:47:56 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACESS STEP LH

Job Number: 33919

Part Number: D206628021BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

EP 07/09/11 (44)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-021

Location: \_\_\_\_\_

PPP Rev: RE

FINAL INSPECTION/W/O RELEASE

14.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

(4)  
20/09/11

Job Completion



U 07-09-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_












QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 8/20/2007 3:09:25 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI ACCESS STEP LH
Job Number : 33919	
Estimate Number : 10855	
P.O. Number :	Part Number : D206628021BL
This Issue : 8/20/2007 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : 8/15/2007 Type : LARGE FAB ASSY	Drawing Revision : N/A
Previous Run : 33756	Material :
Written By :	Due Date : 8/31/2007 Qty: 3 Um: Each
Checked & Approved By :	
Comment : Est Rev:D as per ECN 766 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	DC DOCUMENT CONTROL
 	
Comment: DOCUMENT CONTROL Photocopy blue file and type labels as per PPP D206-628-021 CHG 002	
2.0	33919A 206L /407 STEP ASSY, LH
 	
Comment: Sub-Component SUB-COMPONENT D2724-041 B_____	
3.0	PACKAGING 1 PACKAGING RESOURCE #1
 	
Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
4.0	D27317 Mounting Lug
 	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s) Pick: Qty Part Number Description Batch 4 D2731-7 Mounting Lug _____	
5.0	D2856400 Abrasion Strip
 	
Comment: Qty.: 1.1708 f(s)/Unit Total : 3.5123 f(s) Pick : Qty Part # Description Batch 2 D2856-400 6.9" Abrasion Strip _____	

REFERENCE ONLY

BLUE

Dart Aerospace Ltd.

Date : Wednesday, 15/08/2007 3:48:02 PM  
 User : Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L /407 STEP ASSY, LH
Job Number	: 33919A		
Estimate Number	: 11702		
P.C. Number	: <i>N/A</i>	Part Number	: D2724041
This Issue	: 15/08/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2724 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 33756A	Material	: <i>N/A</i>
Written By	:	Due Date	: 31/08/2007
Checked & Approved By	:	Qty:	<i>4</i> Um: Each
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Extrusion
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <u>332858</u> Check Material for any Dents or Defects <i>PE 01.08.21</i> 4		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 Cut D2724-1 using D2622 extrusion as per Dwg D2724 Deburr and bevel ends for welding <i>PE 01.08.21</i> 4		
3.0	D2734	206 Step Endplate
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) 206 Step Endplate Pick: Qty Part Number Description Batch 2 D2734 End Cap <u>330883</u> <i>PE 01.08.21</i> 4		
4.0	D34581	PLATE
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3458-1 Plate <u>332480</u> <i>PE 01.08.21</i> 4		



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:48:02 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 33919A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description  
2 D3458-3 Plate

Batch

332481

P.E. 07.08.21

4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD Batch:

103794  
104721

Grind end cap welds flush

O.M

07.08.24

4

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

107/08/28 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/28 (4) M

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

O.M 07.08.28

(4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P.E. 07.08.29

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:48:02 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 33919A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig DT

A/R AL ROD Batch: M103794

Grind per dwg D2724

4.4 07.08.29

4

07.08.29 4  
07.08.29 4

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/29 (4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/29 (4LH)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

07.08.29

(4)

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment: Issue P.O. 4496  
Atelier Debosselage

07/08/30

(4)

PTU

Spray Paint Delfleet Blue  
Clear with Delfleet

07/08/30 (4)

16.0


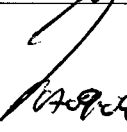
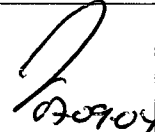
QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

09.04 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
02/04	15-1	receive & inspect.		07/08/31	(4)		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:48:02 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 33919A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M105386



4X

Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

M-1 07/09/04

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/9/11 (4)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

E PDD 33919 7/9/4

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/11

Job Completion



u 07-09-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

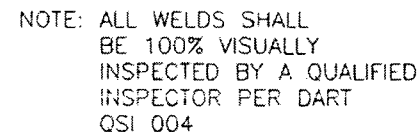
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

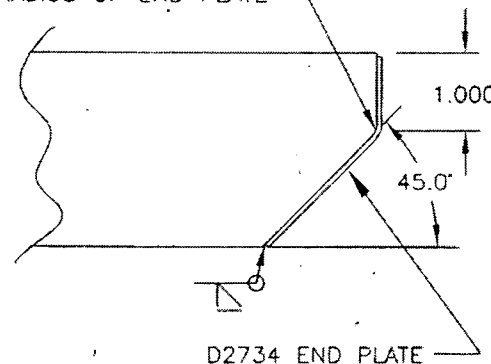
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



- REFER TO STEP  
END DETAIL

D2724-1  
MAKE FROM EXTRUSION D2622-107

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE



D2734 END PLATE

TYPICAL STEP END DETAIL  
NOT TO SCALE

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

1)	MAKE FROM EXTRUSION D2622	TYPICAL S
2)	WELD PER DART QSI 004	NOT
3)	FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4	
4)	ALL DIMENSIONS ARE IN INCHES	
5)	ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED	

# THE LEASER

05-11-19

DART

DESIGN KE	DESIGNED BY PH	DARI AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <del>PH</del>	APPROVED <del>PH</del>	DRAWING NO. D2724	REV. C SHEET 1 OF 1
DATE 05.09.19		TITLE 206L/407 STEP ASSEMBLY	SCALE NTS
A	97.12.04	NEW ISSUE	
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
C	05.09.19	RE-DESIGN, ADD D3458-1/-3	